

5141243



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6103-003
Job Sheet 187806



Part No: D6103-003

Job Qty: 10 ea

Part Name: Round Billet, Aluminum



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/17/18

Job Tracking No:

Due Date: 1/16/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	10 pcs		1/16/19	0.00	0.00	Purchasing		AT 19/01/02
110	Packaging	10 pcs		1/16/19	0.00	0.00	Packaging2		AT 19/01/02
120	QC	10 pcs		1/16/19	0.00	0.00	QC18		61
130	Packaging	10 pcs		1/16/19	0.00	0.00	Packaging3-2		DAS 9-89 19-01-02
140	QC21-SA	10 Ea		1/16/19	0.00	0.00	QC21		21

Part Op 100 - Issue P/O: 42088 a)Description: Alluminum round billet b) Ø3.500" x 12.500" long c) Tolerance on all
Descriptions: dimensions are +0.030"/-0.000" d) Material: 7075-T7351 (QQ-A-225/9) Material certification required
110 - Ensure material certification is attached
130 - LOCATION: MAT043

DEC 18 2018

X10

DAS
13
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6103-003P	Round Alum Billet	10 pcs (1 ea)	100-Purchasing	5141240

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6103-003P	10	0	0

Part Specifications

Specifications could not be found.

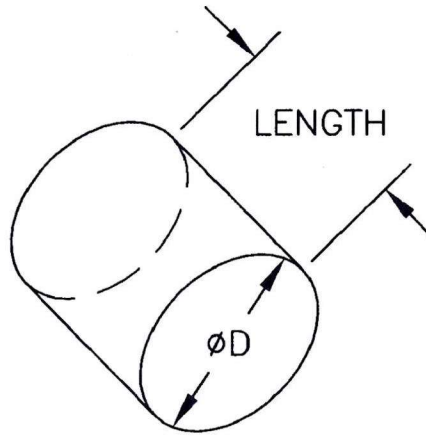
Plex 12/17/18 11:11 AM dart.lavoie.chantal



DESIGN D41	DRAWN BY D41	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042088**

Supplier: MEC002-VU
Metaux Castle
P.O. Box 4090 Stn A
Toronto
ON
M5W OE9 Canada

PO No: PO042088

PO Date: 12/18/18

Due Date: 1/16/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
DEC 18 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	187805	D6102-013P		6061-T6 7.0X6.5X2.0 AS PER DWG D6102 REV. D	Firmed	-	1/16/19	10 pcs	0 pcs	10 pcs	\$31.65/pcs	\$316.50
2 AT	187806	D6103-003P		Round Alum Billet AS PER DWG D6103 REV. B	Firmed	-	1/16/19	10 pcs ✓	0 pcs 11x	10 pcs	\$60.40/pcs AT 19/01/02	\$604.00
3 AT	187840	D6104-003P		17-4 SS Roundbar 3.25"Od AS PER DWG D6104 REV. B	Firmed	-	1/16/19	10 pcs ✓	0 pcs 10x	10 pcs	\$26.70/pcs AT 19/01/02	\$267.00

Grand Total: \$1,187.50

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/18/18 8:25 AM dart.lavoie.chantal

**Castle Metals®**

A. M. Castle & Co.

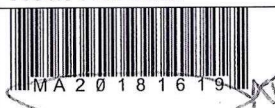
PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 1

Shipment No:3788622

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped	F.O.B.	Freight Terms		Carrier		BOL No	
27-DEC-18	ORIGIN	Prepaid		MANITOULIN		3788622-2	

Shipment Details	Final Destination Branch - TOR
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Order No	Line No	Item No	Description				
5351364	1	8808.MO	3.5000..RD.7075.T7351.ALUMINUM.CF.144.0000 CUT TO 12.5 IN (+ .1250/- .0000 IN) - BAND SAW CUTTING SPECIFICATIONS: AMS-QQ-A-225/9				
Purchase Order No		Part Number	Ordered Qty		Invoice Qty		
42088		YOUR ITEM NUMBER: D6103-003	11.00 PCS		11.00 PCS		
Details		ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #’S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS					
Delivery No.	Mill/Source	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
122472794	ARCONIC INC			11			133.3791

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

DEC 27 2018

Date

SUE KALOUS



Date Printed: 27-DEC-2018 01:33:34 PM

266457602

Certified Inspection Report

08/22/18
12:29:26

Arconic Inc.
ARCONIC ENGINEERED STRUCTURES
45 County Route 42, Massena, NY 13662



Customer Castle A M & Co	Customer P.O. No. 42232	Customer Part No. (8808)	Arconic Order No. MME-C8144-001	Govt. Contract No.
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NOTES:

Ingot Source: Vista Metals GA
Material compliant with DFARS 252.225-7001 (Buy American Act)
Mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product.
This alloy meets the requirements of EU 2011/65/EC (RoHS) and EU 2000/53/EC for lead, mercury, cadmium and hexavalent chromium.

THESE ITEMS ARE CONTROLLED BY THE U.S. GOVERNMENT AND AUTHORIZED FOR EXPORT ONLY TO THE COUNTRY OF ULTIMATE DESTINATION FOR USE BY THE ULTIMATE CONSIGNEE OR END-USER(S) HEREIN IDENTIFIED. THEY MAY NOT BE RESOLD, TRANSFERRED, OR OTHERWISE DISPOSED OF, TO ANY OTHER COUNTRY OR TO ANY PERSON OTHER THAN THE AUTHORIZED ULTIMATE CONSIGNEE OR END-USER(S), EITHER IN THEIR ORIGINAL FORM OR AFTER BEING INCORPORATED INTO OTHER ITEMS, WITHOUT FIRST OBTAINING APPROVAL FROM THE U.S. GOVERNMENT OR AS OTHERWISE AUTHORIZED BY U.S. LAW AND REGULATIONS.

MATERIAL IS OF U.S.A. ORIGIN AND WE HEREBY CERTIFY THE PRICES TO BE TRUE AND CORRECT.

213214507

A small, handwritten signature or mark in the bottom right corner of the page.

Certified Inspection Report

08/22/18
12:29:26

Arconic Inc.
ARCONIC ENGINEERED STRUCTURES
45 County Route 42, Massena, NY 13662



Customer Castle A M & Co	Customer P.O. No. 42232	Customer Part No. (8808)	Arconic Order No. MME-C8144-001	Govt. Contract No.
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Ship To **Castle A M & Co**
2150 Argentia Road
Mississauga, ON L5N 2K7

We hereby certify that the material covered in this report has been inspected in accordance with, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, or as previously agreed to with customer and that samples representative of the material met the composition limits and have the mechanical properties shown on the face of this sheet. Manufactured under a quality management system registered to ISO/AS9100. Melted and manufactured in the USA.

Ted Miller
Ted Miller, Quality Manager

Date Shipped 08/22/18	Weight Shipped 1,974 lbs	Product CFRB-CF ROD	Specific Length	BOL 000166122
Alloy - Temper 7075-T7351	Size 3.50000 IN	Shape DIA	Config 12 FT	QRR

Specifications:

A97075-11 Rev 16 w/exceptions & comments
per Massena QA email 6-22-18
AMS4124E
ASTMB211-12E1
Material conforms to T73 reqmts
Minimum mechanical properties to apply:
68 KSI Tensile Strength
56 KSI Yield Strength
10% Elongation
QQ-A-225/9E (Except Size)
AMS-QQ-A-225/9A (Except Size)

213

213 214507



TEST REQUIREMENTS		Test	Test	Test	Test	Test	Test	Test	Test	Test
		U.T.S.	T.Y.S.	%Elong	Cond					
Max:			67.9							
Min:		68.0	56.0	10.0	38.0					

Test Results		Test	Test	Test	Test	Test	Test	Test	Test	Test
Lot / Work Order		U.T.S.	T.Y.S.	%Elong	Cond					
MA20181619										
No. of Tests	1									
Max:		75.3	65.5	15.0	40.7					
Min:		75.3	65.5	15.0	40.7					

TEST ABBREVIATIONS

U.T.S. Ultimate Tensile Strength KSI
Cond Conductivity % IACS

T.Y.S. Tensile Yield Strength KSI .2% offset

%Elong Elongation % in 2"

Aluminum Association Chemical Composition Limits (in Weight %)

ALLOY	MAX	%SI	%FE	%CU	%MN	%MG	%CR	%ZN	%TI	%Others	%Others	%AL			
7075	MIN	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	Rem			
				1.2		2.1	0.18	5.1		Each	Total				

Actual Started Chemistry

LOT/WORK ORDER	MAX	%SI	%FE	%CU	%MN	%MG	%CR	%ZN	%TI	%OE	%OT	%AL			
MA20181619	MIN	0.08	0.14	1.6	0.03	2.5	0.20	5.8	0.02	LT 0.05	LT 0.15	Rem			
		0.06	0.13	1.6	0.01	2.4	0.20	5.7	0.02						

Certified Inspection Report

08/22/18
12:29:26

Arconic Inc.
ARCONIC ENGINEERED STRUCTURES
45 County Route 42, Massena, NY 13662



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AUTHORIZED FOR EXPORT ONLY TO THE COUNTRY OF ULTIMATE
DESTINATION FOR USE BY THE ULTIMATE CONSIGNEE OR END-USER(S)
HEREIN IDENTIFIED. THEY MAY NOT BE RESOLD, TRANSFERRED, OR
OTHERWISE DISPOSED OF, TO ANY OTHER COUNTRY OR TO ANY PERSON
OTHER THAN THE AUTHORIZED ULTIMATE CONSIGNEE OR END-USER(S),
EITHER IN THEIR ORIGINAL FORM OR AFTER BEING INCORPORATED
INTO OTHER ITEMS, WITHOUT FIRST OBTAINING APPROVAL FROM THE
U.S. GOVERNMENT OR AS OTHERWISE AUTHORIZED BY U.S. LAW AND
REGULATIONS.

MATERIAL IS OF U.S.A. ORIGIN AND WE HEREBY CERTIFY THE
PRICES TO BE TRUE AND CORRECT.

213214507



MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6103-003
 DATE: 19/01/02

PO / BATCH NO.: P0042088 / S141243

MATERIAL CERT REC'D: 161
 QUANTITY RECEIVED: 11x
 QUANTITY INSPECTED: 11x
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 3.50"
 THICKNESS RECEIVED: 3.50"
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒ N	
CORRECT FINISH	☒ Y	N	
CORROSION	Y	☒ N	
CORRECT GRAIN DIRECTION	☒ Y	N	
CORRECT MATERIAL PER M-DRAWING	☒ Y	N	QR-A-2254
CORRECT THICKNESS	☒ Y	N	
PHOTO REQUIRED	Y	☒ N	
CORRECT REF # TO LINK CERT	☒ Y	N	HT-MA20181619
CORRECT MATERIAL IDENTIFICATION	☒ Y	N	
CORRECT M# ON THE MATERIAL	☒ Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS 61</u> DATE: <u>19/01/02</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in